

Date: Monday, 10/22/2007 3:41:31 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	206/OH-58 SADDLE, INBOARD, RIGHT SIDE
Job Number	35280			
Estimate Number	12931			
P.O. Number	:		Part Number	: D29332UP
This Issue	10/22/2007	S.O. No. :	Drawing Number	: D2933 REV C
Prsh Rev.	NC		Project Number	: N/A
First Issue	/ /	Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	34602		Material	:
Written By	:		Due Date	: 11/5/2007 Qty: 8 Um: Each
Checked & Approved By	<u>JLJ 07.10.23</u>			
Comment	Est Rev:	New Issue 07-07-04 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101001	7075-T7351 2X6X6.25
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Issue material from stock: 7075-T7351 QQ-A-250/12 Cut Size 2.0 x 6.25 X 6.00 Grain Along Long 6.00 Length Batch No: <u>B34872</u> SF 08/03/18 (B)
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 5-Deburr SF 08/03/18 (C)
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet SF 08/03/18 (C)
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
		Comment: INSPECT ALL DIM TO DIM SHEET SF 08/03/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 3:41:31 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/0H-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 35280

Part Number: D29332UP

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

SK 08/03/24 (8)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



M107005

M.H.



08/03/25 (8)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 08-03-25

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



HD

08-03-26

(X8)

Comment: INSPECT POWDER COAT

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STG029

10/03/29 (8)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/03/29

Job Completion



bb powder coat white per QSI 005
m.h. 08/03/23 (8X)

mf 08-03-27

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	35280
Description: 206 Saddle, Inboard, Right side				Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.132	.128	.128	.128		
B	0.100	0.140		.132	.130	.127	.127		
C	0.100	0.140		.130	.125	.125	.125		
D	0.210	0.230		.229	.217	.219	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.578	1.578	1.578	1.578		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.313	.313	.313		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.125	.117	.119	.117		
O	0.540	0.560		.543	.548	.551	.550		
P	0.490	0.510		.505	.496	.505	.505		
Q	3.715	3.725		3.719	3.720	3.720	3.720		
R	2.470	2.510		2.496	2.497	2.500	2.500		
S	0.240	0.270		.263	.260	.260	.260		
T	0.100	0.180		.143	.140	.138	.138		
U	1.625	1.635		1.630	1.629	1.629	1.629		
V	1.362	1.372		1.367	1.368	1.368	1.368		
W	0.316	0.321		.321	.321	.321	.321		
X	1.125	1.145		1.134	1.130	1.130	1.130		
Y	1.565	1.585	DT8695 A/B	1.574	1.570	1.570	1.570		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	8F	Audited by:	SD
Date:	08/02/16	Date:	08/03/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	SD

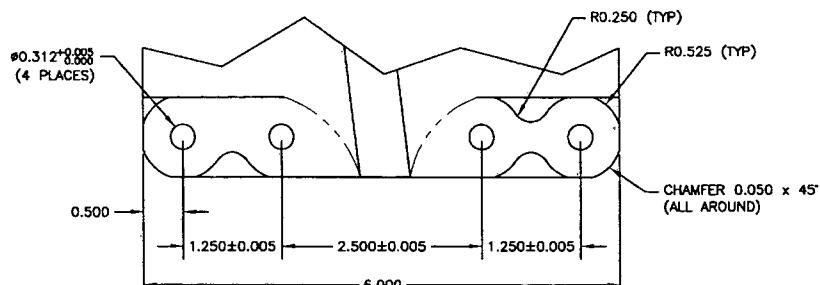
DART AEROSPACE LTD				Work Order:	35280
Description: 206 Saddle, Inboard, Right side				Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	51	826	73	84	By	Date
A	0.100	0.140		.128	.127	.128	.128		
B	0.100	0.140		.128	.125	.128	.124		
C	0.100	0.140		.125	.123	.123	.123		
D	0.210	0.230		.219	.222	.222	.219		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.510	.510	.510	.510		
I	1.572	1.582		1.578	1.578	1.578	1.578		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.237	.237	.237	.237		
N	0.100	0.140		.119	.117	.119	.117		
O	0.540	0.560		.549	.549	.550	.548		
P	0.490	0.510		.505	.500	.505	.505		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.496	2.496	2.500	2.500		
S	0.240	0.270		.261	.261	.262	.261		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.635	1.635	1.635	1.635		
V	1.362	1.372		1.370	1.370	1.370	1.370		
W	0.316	0.321		.321	.321	.321	.321		
X	1.125	1.145		1.130	1.130	1.130	1.130		
Y	1.565	1.585	DT8695 A/B	1.670	1.570	1.570	1.570		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<u>SP</u>	Audited by:	<u>SD</u>
Date:	08/03/18/19	Date:	08/03/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <u>KA</u>	<u>SP</u>

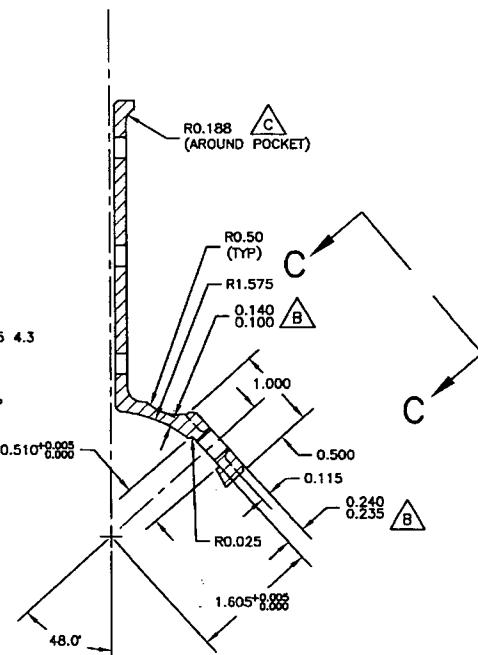


VIEW C-C

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

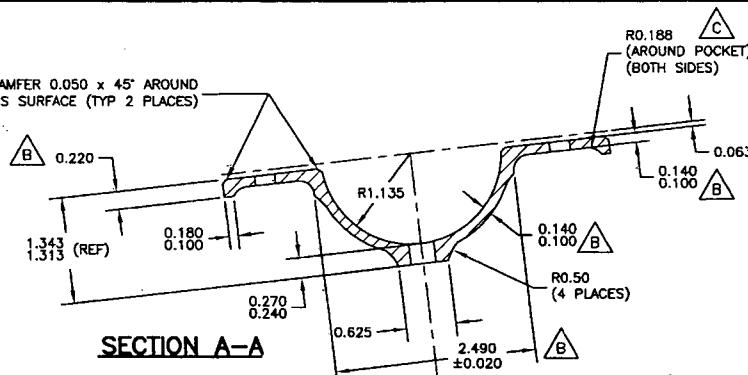
NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QS 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QS 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

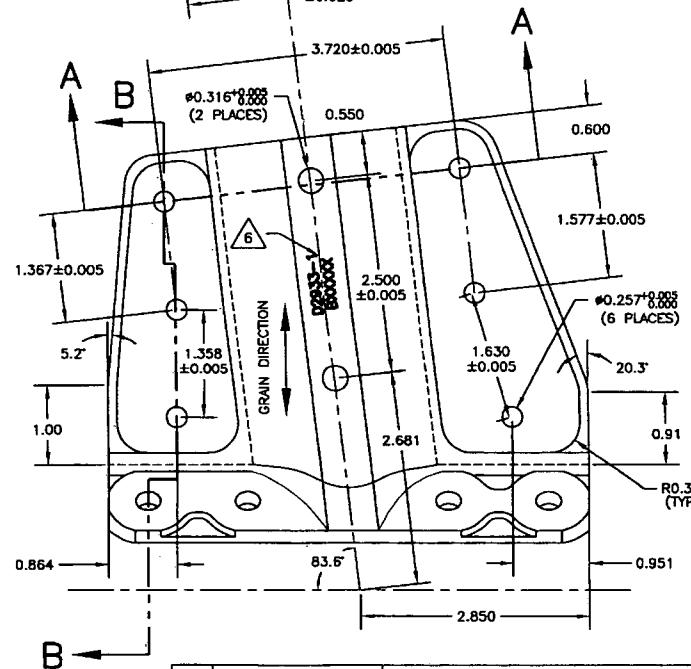


SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	PH	DRAWING NO. D2933 REV. C SHEET 1 OF 1
DATE	06.11.09	TITLE SADDLE INSIDE SCALE 2:3

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 NO. 35280
 07.02.12